

Work Order ID 59235

Friday, May 28, 2010 9:49:19 AM



Page 1

Item ID: D1048

Accept



Setup Start



Revision ID:

Item Name: Saddle

Stop



Start Date: 5/27/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: /

Date: 10-5-28

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D1048

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D1048

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

304.063

B10-69

25

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-69

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Subtotal

ccmbo
25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Powdercoat

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

M112588

0.00

=> 10/06/10

25

d

Powder Coating

Memo

0.00

START TIME: 10:00AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 10:30AM

170



QC

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

10 . 06 . 10 25

180



Packaging

Identify as per dwg & Stock Location:

2

0.00

Memo

0.00

Packaging

16 . 6 . 10 25

W/O:		WORK ORDER CHANGES					
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Required Date: 6/4/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/11

R/10-6-11
(25)

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Picklist Print

Friday, May 28, 2010 9:49:23 AM

Page 1

Work Order ID: 59235

Parent Item: D1048

Parent Item Name: Saddle

Comments: IPP: B ☐ 02.02.22 ☐ Re-format ☐ NG ☐
IPP Rev: C Now on Waterjet 06-12-06 JLM

Start Date: 5/27/2010

Required Date: 6/4/2010

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	6.7443	0.018	0.378947	15		
304/316 Sheet .063													

Location

MAT

Loc Qty

6.74427

Loc Code

111323

0

114467

6.74427

114799

114799

25

1810-6-9

W/O:		WORK ORDER CHANGES					
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RELEASED
97/07/02 RCL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59235

10-5-28

NOTES:

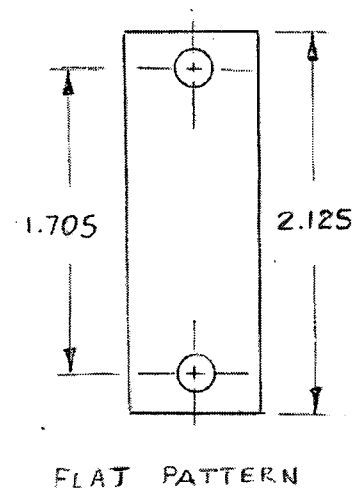
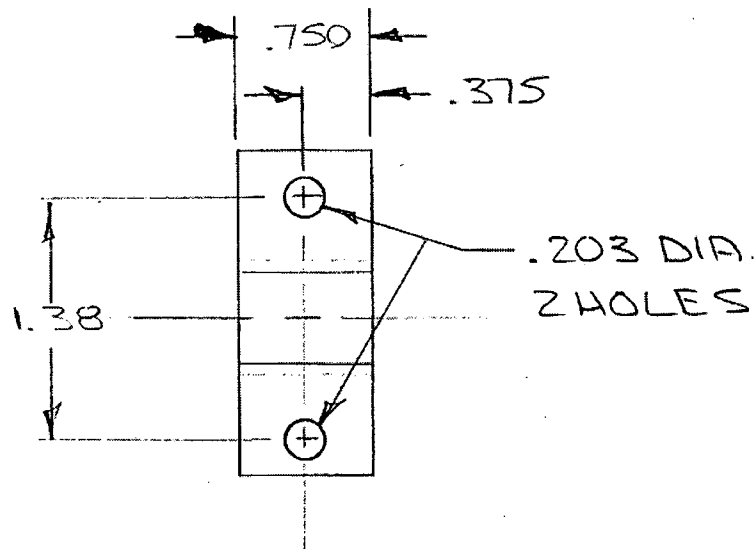
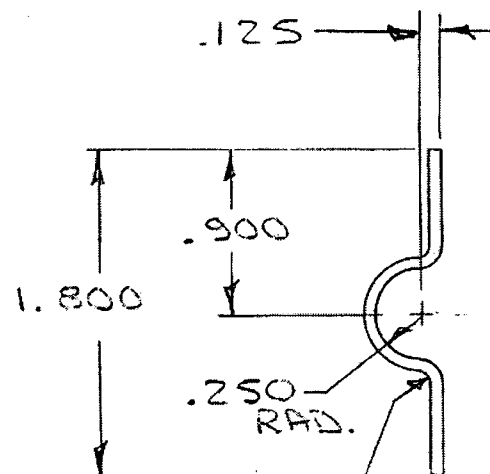
1) MATERIAL

STAINLESS STEEL

T304#2B .062 THICK

2) FINISH: POWDER COAT BLACK SANDTEX (REF. 4.3.5.7)
PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.010 TO 0.020



D1.12.05 ADD FLAT PATTERN	A	REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RIVET CODE SHALL BE PER NAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
	RF	DRAWN		BASIC CODE	DIA. DASH NO. H-HEAD NEAR SIDE F-HEAD FAR SIDE	CONTRACT NO.		DART AERO ACCESSORIES INC. VANCOUVER CANADA		
		APPROVED		D-DIMPLE D-DIMPLE NO. OF SHEETS C-COUNTERSINK	LENGTH DASH NO. W-SPOTWELD	DESIGNER BRADLEY	DATE 5/1/91			
		DESCRIPTION OF CHANGE		BASIC CODES 8HMS704704D 8HMS704764D		TITLE CLAMP				
						CHECKED		CODE	DWG NO. D1048	REV. A

REPORT ALL DISCREPANCIES — DO NOT SCALE

SCALE 1:1 SHT 1 OF 1

D1048

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